

Work Order ID 57241

March 30, 2010 3:35:53 PM



Page 1

Item ID: D2654-5

Accept



Setup Start



Revision ID:

Item Name: Web

Stop



Start Date: 30/03/2010 Start Qty: 3.00



Cust Item ID:

Required Date: 06/04/2010 Req'd Qty: 3.00



Customer:

Reference:

Approvals:

Process Plan:

H

Date: 10-3-30

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2654	Rev E1								
100	Skidtubes	0.00							
	Skidtubes								
	Memo	0.00							
Skidtubes	1-Cut D2600-7 to length as per Dwg D2654 □2-Drill pilot holes in web using drill jig DT 8018-5 as per Dwg D2654 □3-Using the uni-bit, open holes to finish size as per Dwg D2654 □4-Deburr holes and ends								
110	QC5- Inspect part completeness to step on W/O	0.00							
	QC								
Quality Control	Memo	0.00							
120	Chemical Conversion Coat per QSI005 4.1	0.00							
	HandFinish								
Hand Finishing	Memo	0.00							

3

11/2/3/31

3

BE 10/03/31

3

11/2/3/31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Item ID: D2654-5

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Setup Start



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Item Name: Web

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Customer:

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Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

3 BE 10/03/31

140

Identify as per dwg & Stock Location: L6.

0.00



Packaging

Memo

0.00

Packaging

3 M 12/3/31

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/04/07
mf
10-4-7

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NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 57241



Parent Item: D2654-5



Parent Item Name: Web

Start Date: 30/03/2010

Required Date: 06/04/2010

Comments: IPP Rev:D□99.02.04□Fixed typo, Changed procedure□DM□

Start Qty: 3.00

Required Qty: 3.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2600-7-125 140 NP 10-4-6 		Manufactured	No			100	Each	0.0000	3.0000	③	10/3/31	
Extrusion 'I Beam' thick						B41591						

W/O:		WORK ORDER CHANGES					
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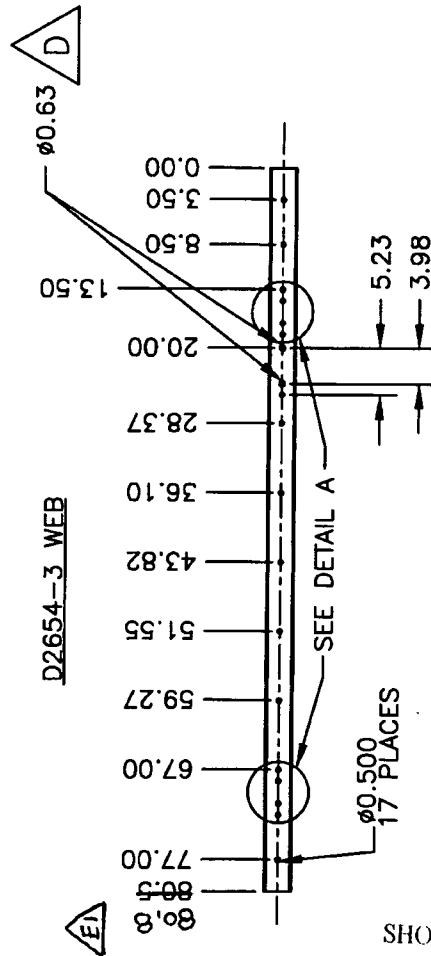
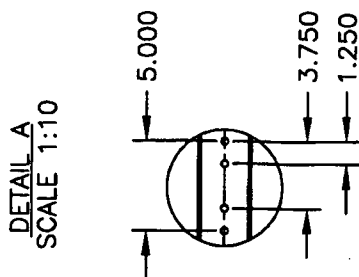
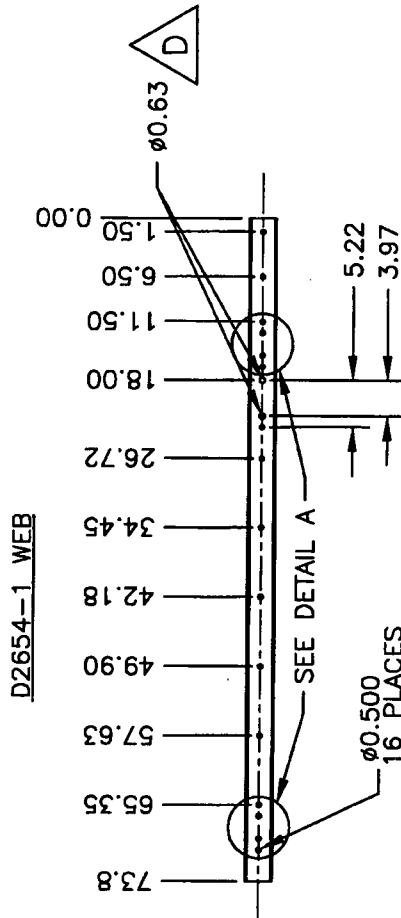
NOTE: Date & initial all entries

DART

DEO ATTACHED



DESIGN <i>CP</i>		DRAWN BY <i>CP</i>		DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>#</i>		APPROVED <i>#</i>		DRAWING NO. D2654	REV. E SHEET 1 OF 2
DATE 04.05.26				TITLE WEB SCALE 1:20	
A	97.03.25		NEW ISSUE		
B	97.06.26		ALTER HOLE PATRN., 0.500 WAS 0.438		
C	97.10.29		CHANGED HOLE PATTERN		
D	98.01.15		GHW HOLES CHANGED TO $\phi 0.63$		
E	04.05.26		CHANGE LENGTHS, REFORMAT		
E1	<i>CP #</i>	04.08.24	PER TOOLING; 80.8 WAS 80.5		

RELEASED
04.06.22

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 57241

MAKE FROM D2600-5-108 EXTRUSION
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

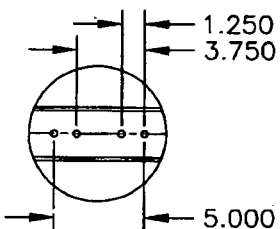


DESIGN	CP	DRAWN BY	CP	DART AEROSPACE USA, INC.
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	PORT HADLOCK, WA
DATE	04.05.26	DRAWING NO.	D2654	REV. E
		TITLE	WEB	SHEET 2 OF 2
		SCALE	1:20	

RELEASED
04.06.22

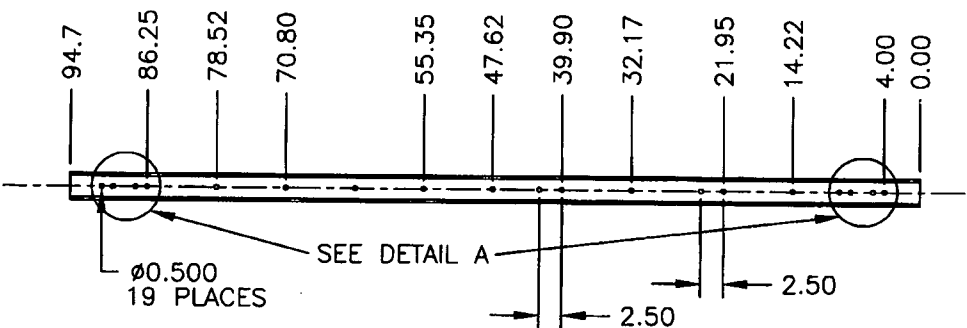
DEO ATTACHED

DETAIL A
SCALE 1:10

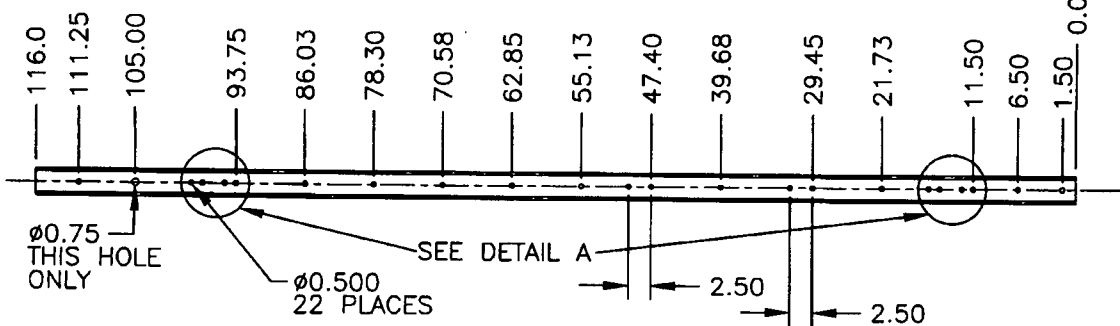


572411

D2654-5 WEB



D2654-7 WEB



MAKE FROM D2600-7-125 EXTRUSION
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

W/O:		WORK ORDER CHANGES					
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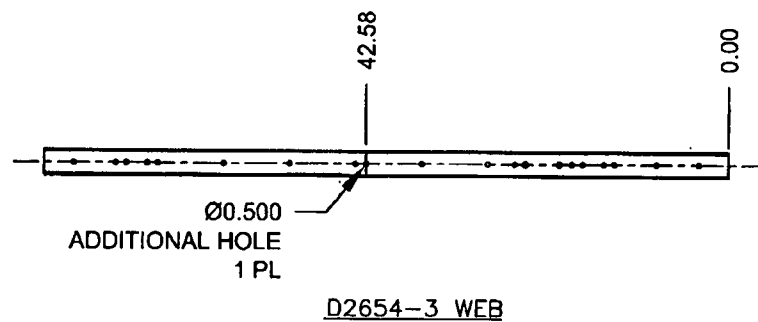
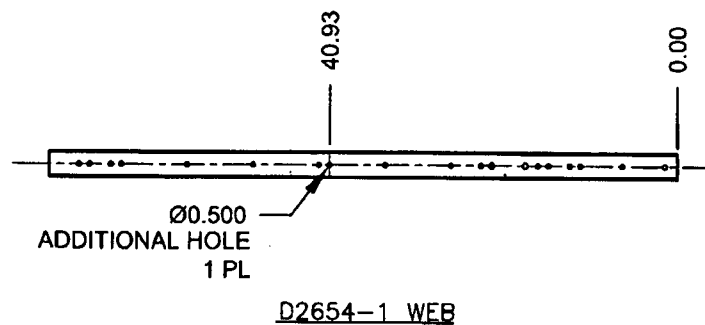
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DRAWING NO. D2654	TITLE WEB	REV. E1	DART AEROSPACE USA, INC ENGINEERING ORDER		D.E.O. NO. D2654-E-2	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>LP</i>	CHECKED <i>PH</i>	MFG. APPR. <i>E</i>	APPROVED <i>MD</i>		DE APPR. <i>PH</i>		
DATE 09.03.11	DATE 09.03.11	DATE 09.04.03	DATE 09.04.03		DATE 09.04.03		

DRILL AN ADDITIONAL HOLE IN THE D2654-1 AND D2654-3 WEB AT THE LOCATION INDICATED:

RELEASED
09/04/08 *MD*



THE ADDITIONAL HOLE IS REQUIRED FOR COMPATIBILITY WITH D3804-041/-043 SKIDTUBE ASSEMBLIES. ALL OTHER INFORMATION REMAINS UNCHANGED.

W1637241

W/O:		WORK ORDER CHANGES					
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